

Work Order ID 55315

January 13, 2010 10:20:27 AM

Page 1

Item ID: D3235-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Mounting Lug

Start Date: 1/13/10 Start Qty: 60.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 60.00

Customer:

Reference:

Approvals: Process Plan:

Date: 10-1-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3235

Rev A

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.820" Batch:

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA369 and Dwg D3235-1. 13-
Debur

120

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Inspect QC6

QC6

QC6

8/10/02/15

PO 11124

Machine per drawing D3235-1 Rev. A

10-1-14

QC

Issue PO to Meter

QC6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55315

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Page 2

Item ID: D3235-1 Accept Setup Start
 Revision ID: Stop
 Item Name: Mounting Lug
 Start Date: 1/13/10 Start Qty: 60.00 Cust Item ID:
 Required Date: 1/20/10 Req'd Qty: 60.00 Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start
 QC: Date: SPC (Y/N): Date: Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120 110 QC Quality Control	QC8- Inspect parts - second check Memo	0.00							
----------------------------------	---	------	--	--	--	--	--	--	--

*Review & inspect for transit damage
ensure L of L attached*

1/13/10 (60)

140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00							
-------------------------------------	---	------	--	--	--	--	--	--	--

=> W 10/02/23 (x60) G

150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00							
------------------------------	---	------	--	--	--	--	--	--	--

8/10/23 (x60)

W/O:		WORK ORDER CHANGES					
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Work Order ID 55315

January 13, 2010 10:20:27 AM



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Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 1/13/10 Start Qty: 60.00



Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 60.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:45am FINISH TIME: 11:15am OVEN TEMPERATURE: 320°F

241 10/02/27 (X60) 2

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BT 10-02-23 (60)

180

Identify as per dwg & Stock Location: 471

0.00



Packaging

Memo

0.00

Packaging

Pc 14/3/0 1 (60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

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Required Date: 1/20/10 Req'd Qty: 60.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/02 HJ
CL 03/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January 13, 2010 10:20:31 AM

Page 1

Work Order ID: 55315



Parent Item: D3235-1



Parent Item Name: Mounting Lug

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP ☐ A ☐ 04.04.19 ☐ New issue ☐ KJ/JLM ☐

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3235-1P		Purchased	No			100	Each	0.0000	60.0000			
lug												
D2423		Manufactured	No			110	f	604.4578	4.3137			
Lug Extrusion												

C203101110

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	604.4578379	
43722	175.629406	
44529	5.7731	
45800	423.055332	

41.3137

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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DART AEROSPACE LTD		Work Order: 53315
Description: Mounting Lug		Part Number: D3235-1
Inspection Dwg: D3235	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010					
0.306	+/-0.010					
1.85	+/-0.030					
R1.20	+/-0.010					
R0.125	+/-0.010					
0.400	+/-0.010					
0.735	+/-0.030					
Ø0.505	+0.005/-0.000					
R0.38	+/-0.030					
3.700	+/-0.005					
0.375	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
R0.380	+/-0.030					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

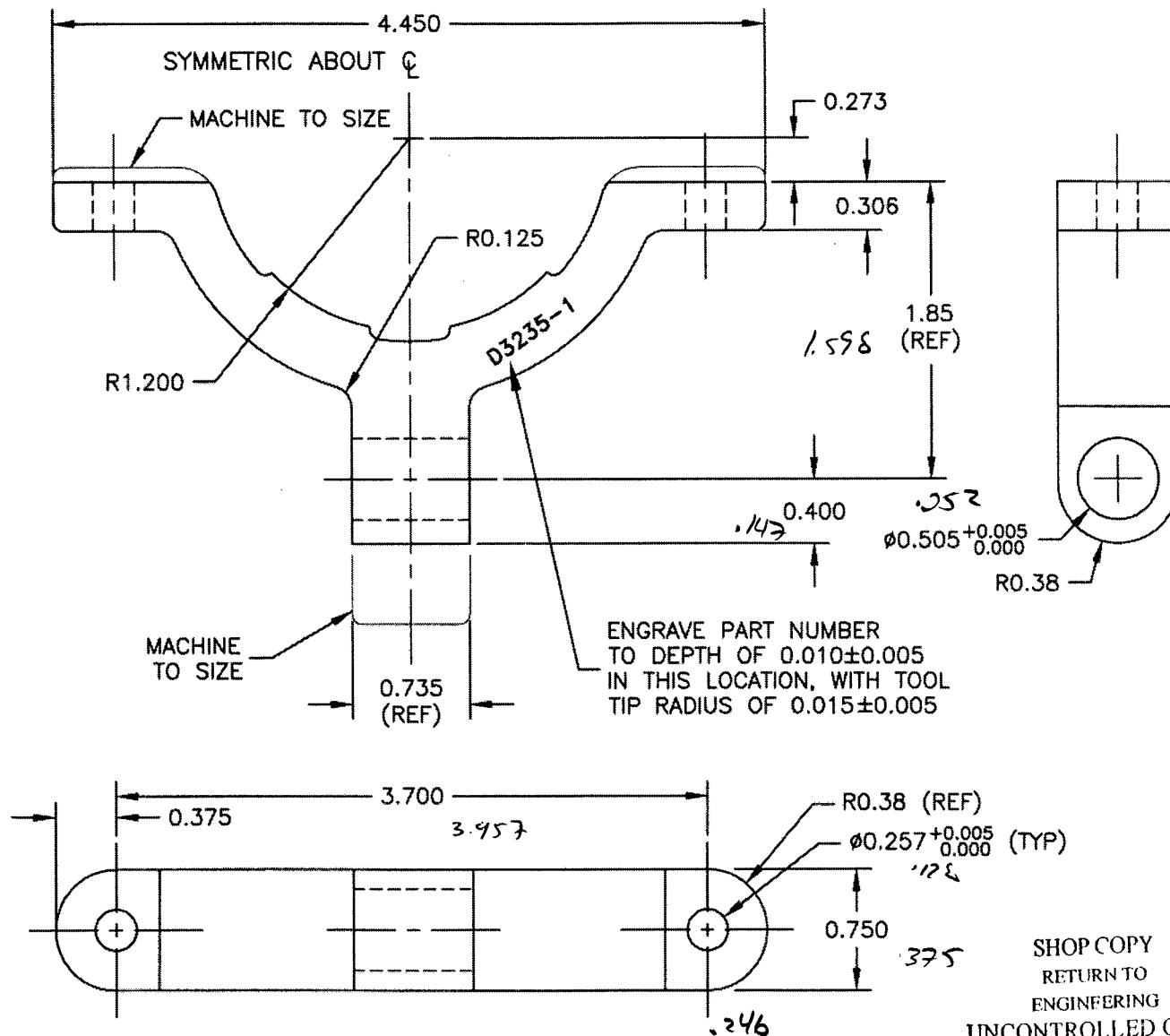
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3235
DATE	04.03.02	TITLE	MOUNTING LUG	REV. A SHEET 1 OF 1
A	04.03.02	NEW ISSUE	SCALE	1:1

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55315

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO**

Purchase Order Date 1/14

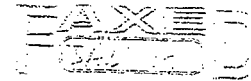
PO Print Date 1/14

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA



Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Requisition Nbr	
Vendor Fax	613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price
1	D2230-3P	LUG	1/18/10 Yes	200.00 Each	Yours ppd	\$10.4000
Special Inst: MACHINE AS PER DWG D2230 REV.F MAT. SUPPLY BY DART D2423 B45800						
2	D3235-1P	lug	1/18/10 Yes	60.00 Each	Yours ppd	\$13.9000
Special Inst: MACHINE AS PER DWG: D3235 REV. A MATERIAL SUPPLY BY DART D2423 B45800						

PO Total:

Change Nbr: 1

Change Date: 1/14/10

No substitution or devi
consent.
Certificate of Conform
Certification required




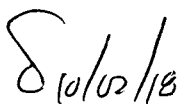
20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17224

Date: Feb 12, 2010

Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 11126	Sold By: Walz, Christian D.
Shipped By: our truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-3 Mounting Lug Material supplied by DART D2423 B45800	Each	200		
D3235-1 Mounting Lug Material supplied by DART D2423 B45800  	Each	60	60	
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

60

D3235-1

Mounting Lug

11126

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

8/10/02/1/8

Vankleek Hill, February 12, 2010